

Work Order ID 86340

June-27-12 3:19:15 PM

86340

Page 1

Item ID: D206-559-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 27/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/28 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D206-559

rev L

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control



7/9/16



7/9/16



12/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86340***86340***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-559-013 Location: <u>12</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Rev. B

10

SP
12-7-16

12/7/18

mf
12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 86340

86340

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:J04.02.17Blank size changedKJ/JLM

IPP Rev:K 07-01-02 Was K10008 JLM

IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC

IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified

By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A

Purchased

No

160

Each

562.0000

12

120

✓

~~AN4-17A~~

Bolt

**

JB

Location

Loc Qty

Loc Code

ST358

300

116704

0

121541

300

76x121541

ST359

262

112314

0

121011

200

44x121011

121068

62

AN4-20A

Purchased

No

160

Each

505.0000

12

120

✓

~~AN4-20A~~

Bolt

**

JB

12/07/13

Location

Loc Qty

Loc Code

GA

50

116419

50

ST359

455

117514

51

121060

104

121541

300

24x121060

94x121541

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86340

Parent Item: D206-559-013

Parent Item Name: Bearpaw

86340

D206-559-013

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased No

160 Each

31.0000

24

240

AN960JD416

Washer

**

121912

JB

SP

Location

Loc Qty

Loc Code

ST351

31

116289

10

119097

21

160 f

122.8682

2.5

25

**

86201

JB

SP

D2182B

Manufactured No

D2182B

Rubber Cushion

Location

Loc Qty

Loc Code

ST410

122.86817

63413

1.6

66063

41.61817

73932

79.65

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274

Manufactured No

D2274

Radius Block

160 Each

759.0000

12

120

**

JB

12/07/13

SP

Location

Loc Qty

Loc Code

ST007

759

78233

2

81958

96

83258

210

84199

251

85455

200

50x83258

50x85455

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D206-559-013

Parent Item Name: Bearpaw

86340

D206-559-013

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 10.00

Required Qty: 10.00

D2432 Manufactured No

160 Each

1.0000

20

D2432

206 (24") Bearpaw

**

84803

Location

Loc Qty

Loc Code

ST499

1

81044

1

160 Each

142.0000

60

D2438 Manufactured No

D2438

Clamp

**

86871

Location

Loc Qty

Loc Code

ST456

142

77038

6

83265

28

83266

50

84804

58

160 Each

761.0000

120

D2529 Manufactured No

D2529

Washer

**

JB

Location

Loc Qty

Loc Code

ST010

761

79485

18

81873

243

84435

500

160 f

510.0000

2.5

25

D2732 Manufactured No

D2732

Rubber Extrusion

**

84432

JB

12/07/13

Location

Loc Qty

Loc Code

ST410

510

70987

14

83560

496

83560

((D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-559-013

Parent Item Name: Bearpaw

86340

D206-559-013

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

160

Each

1,920.000

12

120

**

JB

12/07/13

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

1920

119075

116

121011

193

121444

1311

121652

300

121444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP